

Work Order ID 142130

February 29, 2016 9:02:16 AM

142130

Page 1

Item ID: D6102-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle Billet

Start Date: 2/29/2016 Start Qty: 4.00

Required Date: 3/4/2016 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: SJADate: 20160229

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D6102

Rev D

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 31577 a) Description: Aluminum Billetb) 6.500" x 8.250" x 2.500" thickc) Tolerance on all dimensions is +0.06/0.00d) Grain direction along 6.500" lengthe) Material: 6061-T6/T6511 (QQ-A-250/11 or QQ-A-200/8)Material release certifi

6 MAR 01 2016DAS
13
9-89

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure material certification is attached

6 x 8p/6 03-21

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

Check certification to Dwg D6102 for compliance

6DAS
14
9-8916/03/22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 142130

February 29, 2016 9:02:16 AM

142130

Page 2

Item ID: D6102-011 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle Billet
Start Date: 2/29/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 3/4/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: MAT040	0.00							
130									DAS
Packaging	Memo	0.00							14
Packaging	LOCATION: MAT040								C-39
									16/03/22
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MCS MAR 22 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

February 29, 2016 10:45:14 AM

Page 1

Work Order ID: 142130

142130

Parent Item: D6102-011

D6102-011

Parent Item Name: Saddle Billet

Start Date: 2/29/2016

Required Date: 3/4/2016

Start Qty: 4.00

Required Qty: 4.00

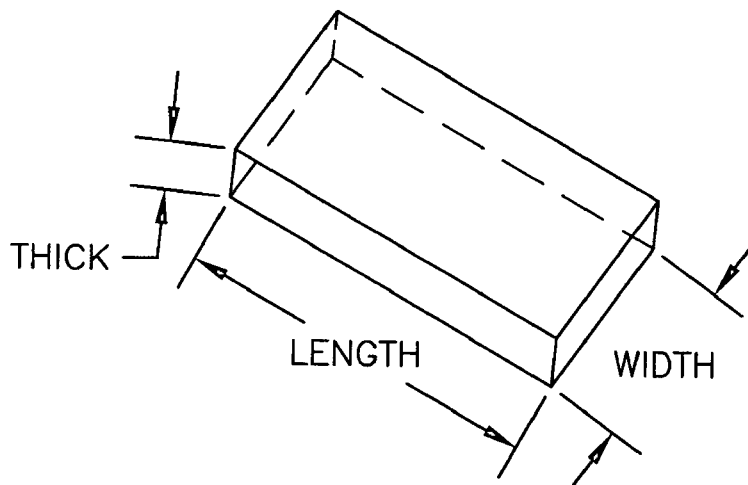
Comments: IPP A04.08.19New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-011P *D6102-011P* 6061-T6 8.25X6.5X2.5		Purchased	No				Each	0.0000	**	4 COR 8/21/16 03-21			



DESIGN #	DRAWN BY PH	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D6102	Rev. D SHEET 1 OF 1
DATE 06.06.30		TITLE SADDLE BILLET, 6061	SCALE NTS
A	01.03.30	NEW ISSUE	
B	03.10.20	ADD D6102-005/-007/-009	
C	04.08.25	ADD D6102-010/-011	
D	06.06.30	ADD D6102-013	

SPECIFICATION CONTROL DRAWING



RELEASED

06.08.15 #

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.06/-0.00), AND GRAIN DIRECTION AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.06/-0.00.

ALL DIMENSIONS ARE IN INCHES.

SH 142130
20160229

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6102-001	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.880	6.250	2.000	Along 7.880 Length
D6102-003	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.000	6.250	2.000	Along 6.000 Length
D6102-005	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	47.85	15.250	1.000	Along 47.85 Length
D6102-007	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.500	7.000	2.500	Along 7.500 Length
D6102-009	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	11.000	6.000	5.000	Along 11.000 Length
D6102-010	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.950	8.250	2.500	Along 7.950 Length
D6102-011	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.500	8.250	2.500	Along 6.500 Length
D6102-013	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.500	7.000	2.000	Along 6.500 Length

Copyright © 2001 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO31547

Purchase Order Date 3/1/2016

PO Print Date 3/1/2016

Page Number 1 of 3

Order From :
METAUX CASTLE
P.O. BOX 4090 STN A
TORONTO, ONTARIO M5W OE9
CANADA

VU-MET002

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
50

Contact Name
Vendor Phone

Ship To Contact
Ship To Phone

Ship Via: Yours ppd

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

USD

Destination-Collect

MAR 01 2016

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D6102-011P AS PER DWG D6102 REV. D B142130 SIZE: 6.500" X 8.250" X 2.500" THICK GRAIN DIRECTION ALONG 6.500"	6061-T6 8.25X6.5X2.5	3/15/2016 Yes 3/15/2016		6.00 Each	\$51.05	\$306.30
Line Total:							\$306.30
2	D6104-011P AS PER DWG D6104 REV. B B142140 MATERIAL: 17-4 PH SIZE: 6.50" X 4.100" LONG	17-4 SS Roundbar 6.50"Od	3/15/2016 Yes 3/15/2016		10.00 Each	\$115.00	\$1,150.00
Line Total:							\$1,150.00

Note:

3/1/2016

**Castle Metals®**

A. M. Castle & Co.

PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 1 of 2

Shipment No:2919101

Ship From: A. M. CASTLE & CO. 2150 ARGENTIA ROAD MISSISSAUGA, ON L5N 2K7 CAN		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped 18-MAR-16	F.O.B. ORIGIN	Freight Terms Prepaid		Carrier MANITOU LIN		BOL No 2919101-2	

Shipment Details	Final Destination Branch - TOR
-------------------------	---------------------------------------

Order No 4270629	Line No 1	Item No 14670.MO	Description 2.5000.PL.6061.T651.ALUMINUM.48.5000.144.5000 CUT 2SIDED TO 8.25 IN (+ .0620/- .0000 IN (HT # 156714B8 ONLY)) X 6.5 IN (+ .0620/- .0000 IN (GRAIN TO RUN ALONG 6.5")) - ALUMINUM PLATE SAW SPECIFICATIONS; AMS 4027				
Purchase Order No 31547		Part Number YOUR ITEM NUMBER: D6102-011		Ordered Qty 6.00 PCS		Invoice Qty 6.00 PCS	
Details		ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #'S Email P/s and certs to: clavoie@dartaero.com END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS					
Delivery No. 120368488	Mill KAISER ALUMINUM	Heat Number 	Mech Id 156714B8	PCS 6	Width (IN)	Length (IN)	Shipped Qty(LBS) 80.7212

These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned.

These commodities, technology or software were exported from the United States in accordance with the Export Administration Regulations. Diversion contrary to US law prohibited.

Date Printed: 18-MAR-2016 05:18:22 PM



Castle Metals®

A. M. Castle & Co.

PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 2 of 2

for credit.		
Reviewed by Authorized Castle Metals Representative:		Date:
		Name:

MAR 18 2016





SHIP TO:

A M CASTLE & CO
1625 TILLIE LEWIS DRIVE
STOCKTON, CA 95206

KAISER
ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

SOLD TO:

AM CASTLE & CO- SOLD TO
1420 KENSINGTON RD
SUITE 220
OAK BROOK, IL 60523

CERTIFIED TEST REPORT

Serial Number

4398863

CUSTOMER PO NUMBER: 340560		WORK PACKAGE: 14670		CUSTOMER PART NUMBER:		SHIP RUN/LOAD: 103400/10		GOVT CONTRACT NUMBER:	
KAISER ORDER NO: 1197319	LINE ITEM: 1	SHIP DATE: 28-NOV-2015	ALLOY: 6061	CLAD: BARE	TEMPER: T651	PRODUCT DESCRIPTION: KaiserSelect Precision Plate			
WEIGHT SHIPPED: 5268 LB	QUANTITY: 3 PCS EST.	TRUCK B/L #: 2057253	GUAGE: 2.5000 IN (63.5000 MM)	DIAMETER/WIDTH: 48.500 IN (1231.9 MM)		LENGTH: 144.500 IN (3670.3 MM)			

MHU 1946565: LOT 15671488: 1 pieces;

MHU 1946650: LOT 781534A3: 2 pieces;

DAS

14

9-89

16/03/22

Certified Specifications

AMS 4027/RevN

EN 10204-3.1/Rev2004

ASME SB 209/Rev2010

ASTM B 209/Rev14

Test Code: 1511

Test Results

Lot: 15671488

Cast 384

Drop 96

Ingot 5

Melted in USA

(ASTM E8/B557)

(EN 2002-1)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T651	LT / 2 (Min:Max)	47.7 : 48.1 (329 : 332)	42.2 : 43.2 (291 : 298)	13.9 : 13.9

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual(wt%)	0.71	0.5	0.29	0.07	1.1	0.19	0.09	0.02	0.01	0.00	TOT 0.06

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4398863

Lot: 781534A3 Cast 400 Drop 13 Ingot 4 Parent Lot: 156713B0 Melted in USA

(ASTM E8/B557)
(EN 2002-1)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T651	LT / 2 (Min:Max)	47.6 : 48.1 (328 : 332)	42.6 : 42.9 (294 : 296)	14.4 : 14.8

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual(wt%)	0.68	0.6	0.29	0.07	1.0	0.20	0.09	0.02	0.01	0.00	TOT 0.08

ALLOY LIMITS

	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
6061												
MIN(wt%)	0.40	0.0	0.15	0.00	0.8	0.04	0.00	0.00	0.00	0.00	EACH	0.05
MAX(wt%)	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.05	TOT	0.15

Aluminum Remainder

ORDER COMMENTS
AMC A98061-162 R 2
AMS 4027, ASTM B209

TEST NOTES

6061 sheet or plate certified to AMS 4025, AMS 4026, or AMS
4027 also meets applicable requirements of cancelled
specification AMS-QQ-A-250/11, Rev. A.

CASTLE METALS STO

HEAT NUMBER 156714B8
MECHANICAL ID 14610
ITEM CODE 14610
LOT NUMBER 340560
PURCHASE ORDER Kaiser
SUPPLIER Kaiser
SPECIFICATION/LCS 12-8
COMMENT 12-8
APPROVED/DATE 12-8

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC (Kaiser), is ISO 9001:2008/AS9100C certified and hereby certifies that all material shipped under this order:
* has been inspected, tested, and found to be in conformance with the requirements of the specifications indicated herein. For material thicknesses outside specification limits, mechanical properties are as shown herein and chemical composition meets specification requirements.
* was melted in the United States of America or a qualifying country per DFARS 225.872-1(a), was manufactured in the United States of America, and meets the requirements of DFARS 252.225 for domestic content.
* has been thermally processed in compliance with AMS 2772, where applicable.
* is mercury free, within the limits of detection of ASTM E1251 (C = 1ppm).
* is in compliance with RoHS 2, European Union Directive 2011/65/EU.
* is in compliance with and regularly monitors any updates to the European Chemical Agency, ECHA, REACH regulations, (EC) n°1907/2006.
* is free of Conflict Minerals, as defined in Section 15.2 of the Dodd-Frank Act.
Any warranty is limited to that shown on Kaiser Aluminum's standard general terms and conditions of sale. Test reports are on file, subject to examination. Test reports shall not be reproduced except in full, without the written approval of the Kaiser Aluminum laboratory. The recording of false, fictitious or fraudulent statements or entries on the certificate may be punished as a felony under federal law.

James Hemenway

JAMES HEMENWAY, LABORATORIES SUPERVISOR



Castle Metals®

A.M. Castle & Co.

INTRA-COMPANY TRANSFER PROFORMA INVOICE

Vendor (Name and Address) A.M. Castle & Co. - WICHITA EAST - CASTLE METALS A. M. Castle & Co. 3050 S HYDRAULIC WICHITA, KS 67216 Tax Registration Number: 36-0879160		Date of Direct Shipment 09-MAR-16 Other References (Include Bill of Lading No.) 2911711-2		Place PRO Number Here
Consignee (Name and Address) A.M. Castle & Co. - TORONTO - CASTLE METALS A. M. Castle & Co. (Canada) Inc. 2150 ARGENTIA ROAD MISSISSAUGA, ON L5N 2K7 Tax Registration Number: 13835 3438 RC0001		Purchaser (Name and Address) A.M. Castle & Co. - TORONTO - CASTLE METALS A. M. Castle & Co. (Canada) Inc. 2150 ARGENTIA ROAD MISSISSAUGA, ON L5N 2K7 Tax Registration Number: 13835 3438 RC0001		
Transportation UPS		Conditions of Sale and Terms of Payment 1% 10, NET 30		
INCO Term: DDP - MISSISSAUGA, ON, L5N 2K7, CAN		Currency of Settlement USD		

Item	Specs of Commodities				Tariff Code	Export License		ECCN	ITAR
	Order-Line-Ship	# Pkgs.	Weight	Heat	Country of Origin	Units	UOM	Price per Unit	Total Price
14670.MO	2.5000.PL.6061.T651.ALUMINUM.48.5000.144.5000				7606123030	NLR		EAR99	N/A
	4270629-1-1	1	80.72 LBS	156714B8	US	6.00	PCS	\$1.7618	\$142.21

Invoice Package Total	Total Weights		Invoice Total	Originator (Name and Address) A.M. Castle & Co. - Wichita East 3050 S HYDRAULIC 171730860 WICHITA, KS 67216 UNITED STATES
	Net	Gross		
I	80.72	80.72	\$142.21	Signature: <i>Devin R. Patterson</i> 
* Price per UOM and Total Price have been adjusted to include Processing and Handling Charges if applicable.				

THESE COMMODITIES, TECHNOLOGY, OR SOFTWARE WERE EXPORTED FROM THE UNITED STATES IN ACCORDANCE WITH THE EXPORT ADMINISTRATION REGULATIONS. DIVERSION CONTRARY TO U.S. LAW PROHIBITED

3/11/2016 16:16 PM

**Castle Metals®**

A.M. Castle & Co.

North American Free Trade Agreement - CERTIFICATE OF ORIGIN

Exporter Name A.M. Castle & Co. A. M. Castle & Co. 3050 S HYDRAULIC WICHITA, KS 67216 Tax Identification Number: 36-0879160	Reference Number 2911711-2
Producer Name Tax Identification Number: Available Upon Customs Request	Importer Name A.M. Castle & Co. A. M. Castle & Co. (Canada) Inc. 2150 ARGENTIA ROAD MISSISSAUGA, ON L5N 2K7 Tax Identification Number: 13835 3438 RC0001

Description of Good(s)		Heat Number	HTC	Preference Criterion	Producer	Net Cost	Country of Origin
14670.MO	2.5000.PL.6061.T651.ALUMINUM.48.5000.144.5000	156714B8	760612	B	No2	No	US

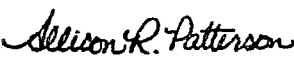
I certify that:

The information on this document is true and accurate and I assume responsibility for proving such presentations. I understand that I am liable for any false statements or material omissions made on or in connection with this document;

I agree to maintain and present upon request, documentation necessary to support this certificate, and to inform, in writing, all persons to whom the certificate was given of any changes that would affect the accuracy or validity of this certificate;

The goods originated in the territory of one or more of the parties, and comply with the origin requirements specified for those goods in the North American Free Trade Agreement, and unless specifically exempted in Article 411 or Annex 401, there has been no further production or any preparation outside the territories of the parties; and

This certificate consists of _____ pages, including all attachments.

Authorized Signature:  	Company: A. M. Castle & Co.	
Name (Print or Type): Allison R. Patterson	Title: Transportation Assistant	
Date: 3/11/16	Telephone: 316-522-5900	Fax:

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D6102-011
 DATE: 16/03/22

PO / BATCH NO: 31547/142130

MATERIAL CERT REC'D: yes
 QUANTITY RECEIVED: 6
 QUANTITY INSPECTED: 6
 QUANTITY REJECTED: _____

THICKNESS ORDERED: 6.50x8.25x2.50
 THICKNESS RECEIVED: 6.50x8.25x2.50
 SHEET SIZE ORDERED: _____
 SHEET SIZE RECEIVED: _____

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	☒	☒	
CORRECT FINISH	☒	☒	
CORROSION	☒	☒	
CORRECT GRAIN DIRECTION	☒	☒	
CORRECT MATERIAL	☒	☒	
CORRECT THICKNESS	☒	☒	
PHOTO REQUIRED	☒	☒	
CORRECT MATERIAL	☒	☒	
CORRECT REF # TO LINK CERT	☒	☒	
CORRECT MATERIAL IDENTIFICATION	☒	☒	
CORRECT M# ON THE MATERIAL	☒	☒	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	☒	☒	
DOES THIS REQUIRE AN EXTRUSION REPORT	☒	☒	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW				
	HRC	HRB	DUR A	DUR D
TYPE OF MATERIAL				
SIZE OF TEST SAMPLE				
HARDNESS / DUROMETER READING				

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>DAS</u> <u>14</u> DATE: <u>16/03/22</u>	SIGNED OFF BY: _____ DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

MATERIAL RECEIPT INSPECTION FORM

INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK

- 1- VERIFY STOCK TO DART PURCHASE ORDER
- 2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
 - a WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
- 3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc.
- 4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
- 5- VERIFY MATERIAL CERTS ARE CORRECT TO THE DART PO INSTRUCTIONS
- 6- REMOVE / CUT A PIECE OF MATERIAL FOR SAMPLE HARDNESS TESTING

INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION

- 1- VERIFY TO DART SUPPLIED DRAWING
- 2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVED INTO DART
- 3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
- 4- VERIFY THAT MATERIAL CERTS MATCH TO WHATS CALLED UP ON THE DART DRAWING

AFTER MATERIAL PASSES INSPECTION

- 5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN 20pcs FOR FULL INSPECTION
- 6- INSPECT ALL DIMS AS PER DRAWING REQUIREMENTS

INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL

- 1- VERIFY MATERIAL CERTS MATCH THE REQUIREMENTS ON THE DART DRAWINGS
- 2- INSPECT MIN HALF THE BATCH OF EXTRUSION RECEIVED INTO DART
- 3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
 - a WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
 - b OUTSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - c INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - d STRAIGHTNESS @ CENTER OVER 12" SPAN
 - e WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
- 4- IDENTIFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE2 . .) AND W/O# AND PO#
- 5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC COORDINATOR BEFORE GOING FURTHER